

Work Order ID 73384

Wednesday, August 31, 2011 1:44:43 PM

Page 1

Item ID: D3557-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 9/1/2011 Start Qty: 24.00

Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 24.00

Customer:

Reference:

Approvals: Process Plan: ME Date: 11-08-01 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3557	Rev A

100 0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3557 ☐ Dwg Rev: A ☐ Prog Rev: A

6061 . 125

☐ ****Ensure Grain Direction is Correct**** ☐ 2-Deburr if necessary

B11-9-8

33

110 0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-9-8

120 0.00

QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Count
x33

S. L. L. L.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 9/12/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
	NC BRAKE					(33)			
Brake NC	Memo	0.00							
Brake NC	Bend as per Dwg D3557								
140		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
150		0.00							
	Chemical Conversion Coat per QS1005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									

SB 11/09/13

8 x 10/13

Counted
33x Ø M-L 11/09/13

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Revision ID:

Item Name: Bracket

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Start Date: 9/1/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

8-20

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-50

33x Ø M-14/09/14

Powder Coating

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

counted.

33 d M-14/09/14

180

Identify as per dwg & Stock Location 067

0.00



Packaging

Memo

0.00

Packaging

14/9/14 (33)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



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Stop



Item Name: Bracket

Start Date: 9/1/2011 Start Qty: 24.00



Cust Item ID:

Required Date: 9/12/2011 Req'd Qty: 24.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/9/14

CME
11-09-14

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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 1:44:39 PM

Page 1

Work Order ID: 73384

Parent Item: D3557-1

Parent Item Name: Bracket




Start Date: 9/1/2011

Required Date: 9/12/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125  6061-T6 .125 Sheet		Purchased	No			100	sf	131.1700	0.0343	0.866526	1-5		



11-9-8

Location

Loc Qty

Loc Code

MAT021

131.17

113608

77.17

118217

54

118217

(33)

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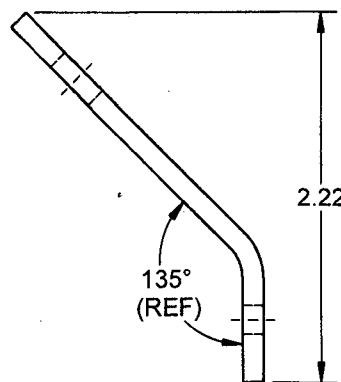
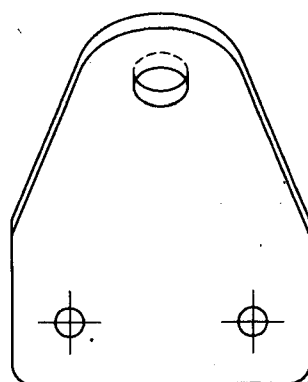
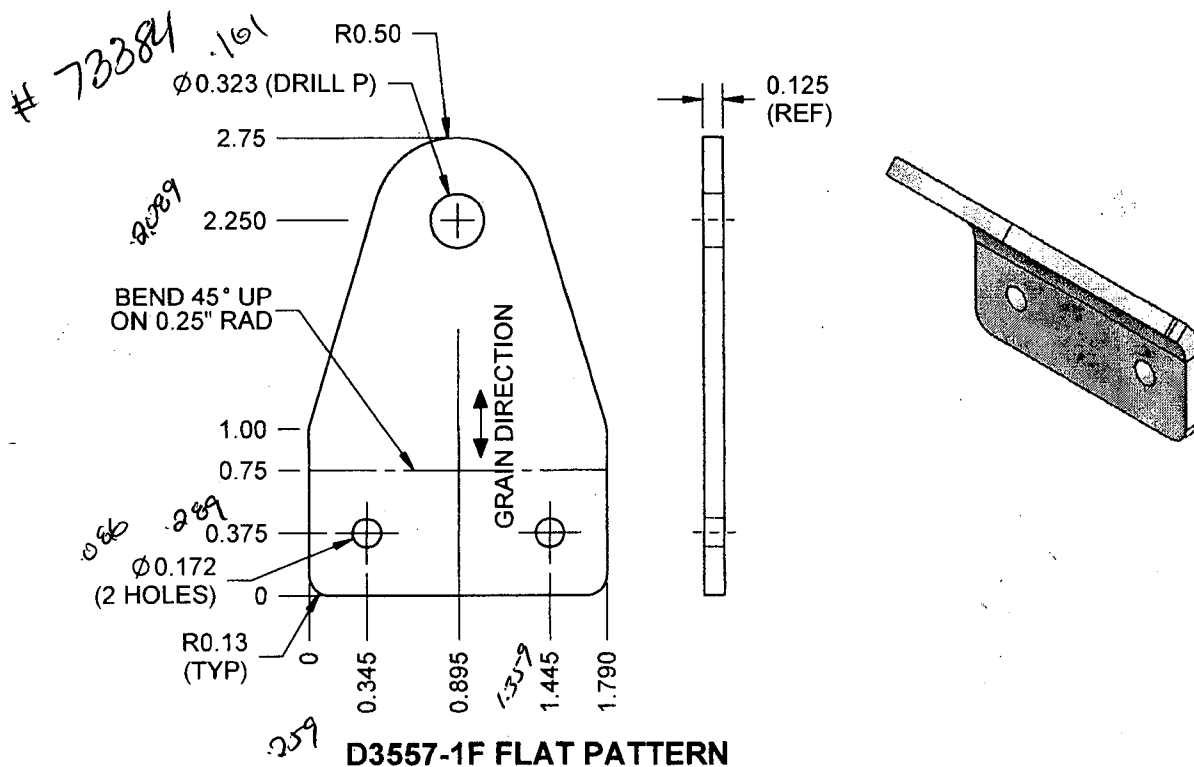
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DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3557	REV. A SHEET 1 OF 1
DATE 06.09.15	TITLE BRACKET		SCALE 1:1
REV A	DATE 06.09.15	DESCRIPTION NEW ISSUE	



D3557-1 BRACKET

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM 0.125 THICK PER QQ-A-250/11 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.5.3.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) IDENTIFY WITH P/N D3557-1 USING FINE POINT PERMANENT MARKER

RELEASED
06.10.13

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